

Work Order ID 67527 - 2

Monday, March 28, 2011 9:06:54 AM

Splht.



Page 1

Item ID: D3319-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan:

Date: 3/28/2011 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319 ☒ Dwg Rev: S ☒ Prog Rev: S ☐ 2-
Deburr if necessary

B11-3-28

1010 090



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-28

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Jul 03/28



Shp 02/04

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Item Name: Wearplate

Stop



Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



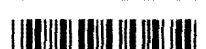
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod M117139								
170 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

160 11-4-11 96
B 11-21-11

8.10.12

8.10.12

416

Work Order ID 67527

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Page 4

Item ID: D3319-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 12.00

Required Date: 3/31/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:55

OVEN TEMPERATURE:

320°

FINISH TIME:

11:25

6 BR 11-4-12

200

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

6 φ 11/4/12

210

Packaging

0.00

Packaging

Memo

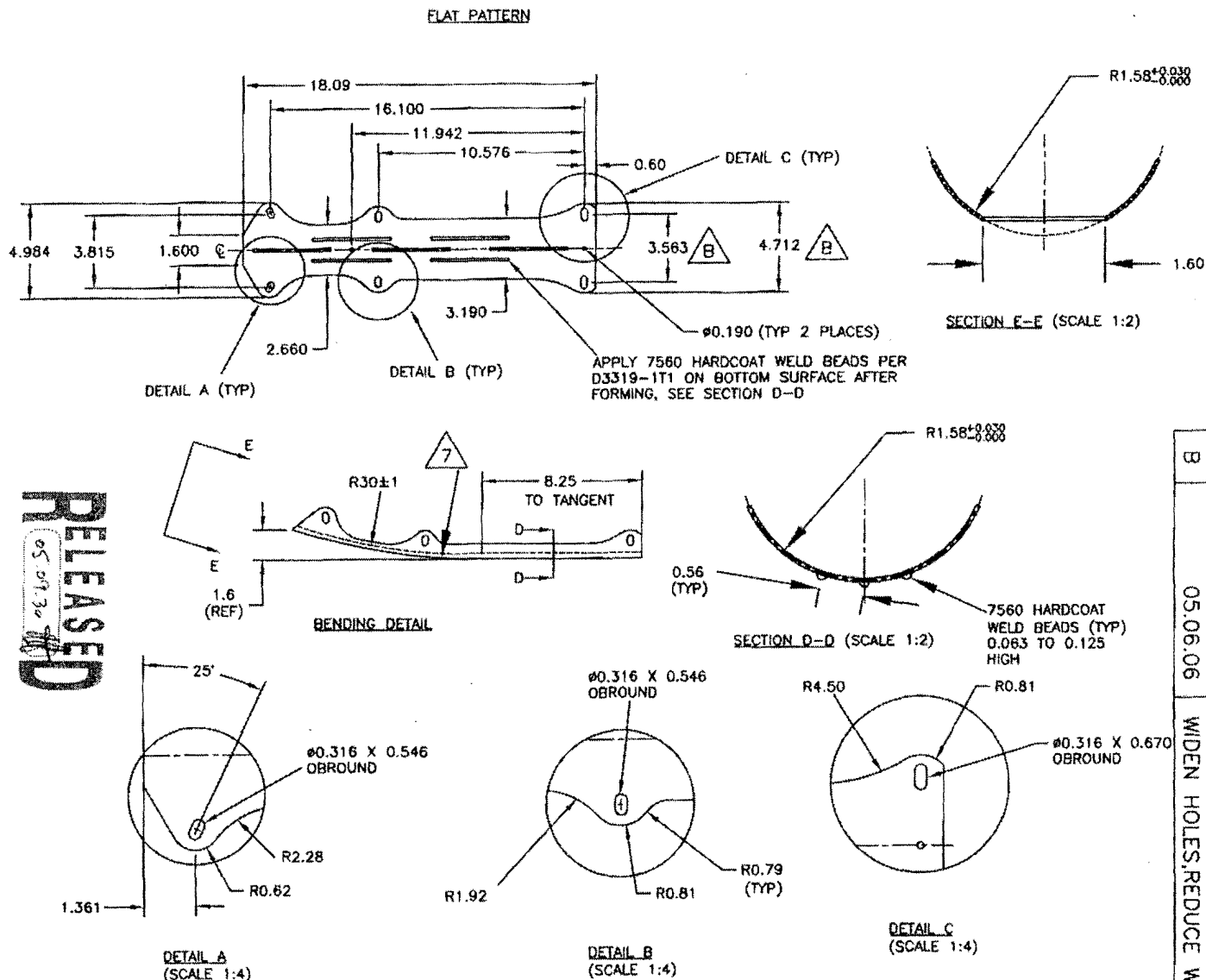
0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: E.TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-3, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: 494

11/4/12 5/16

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D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

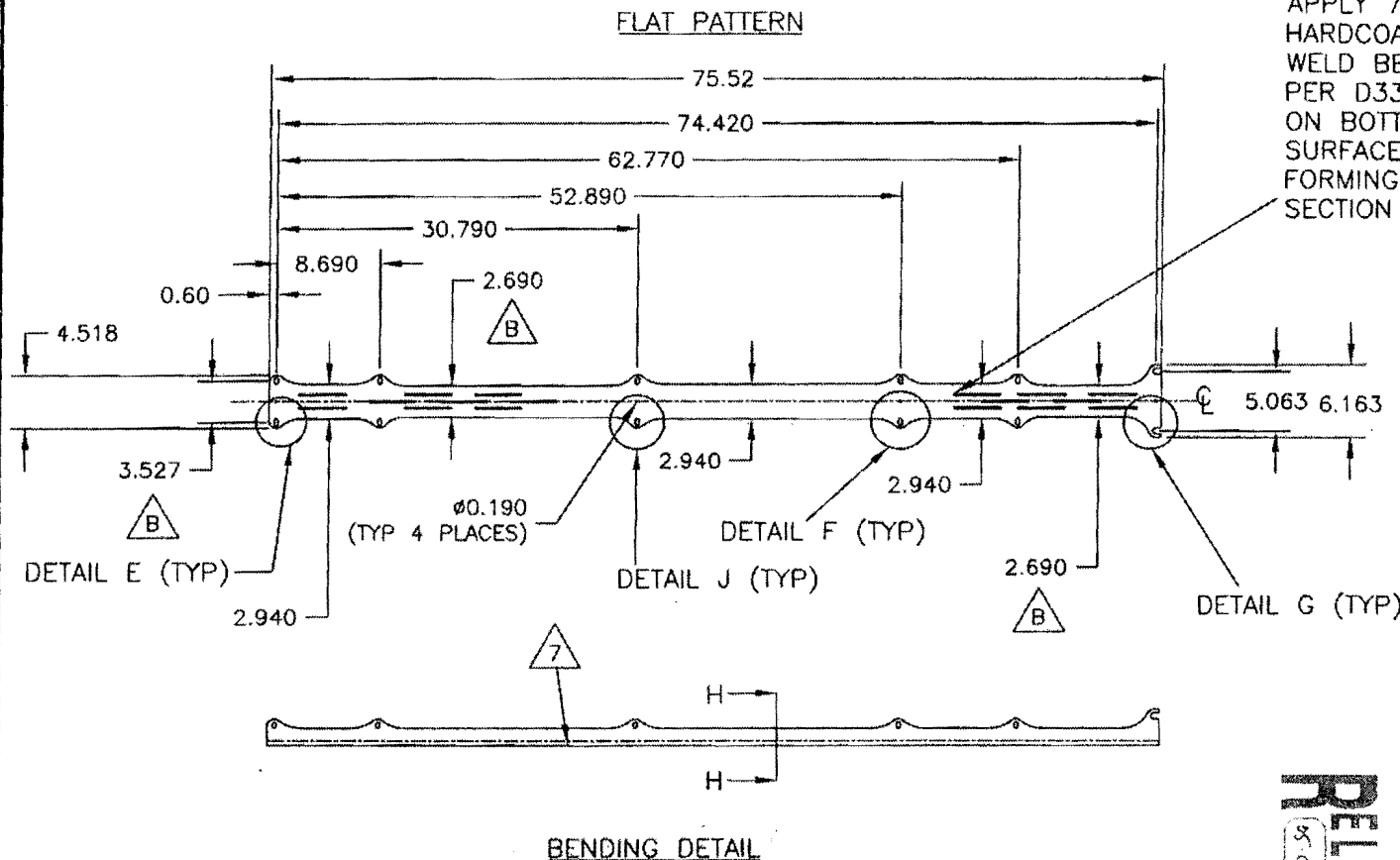
DART
COPY
TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WITHOUT NOTICE
WORK ORDER
NO. 67527

0111-03-25

DESIGN		DRAWING BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
H1		H1		REV. B	
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 5	
H1	H1	D3319		SCALE	
DATE	TITLE		SCALE		
05.06.06	WEARPLATE		1:8		
A	04.09.24	NEW ISSUE			
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7			

DART

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



RELEASED

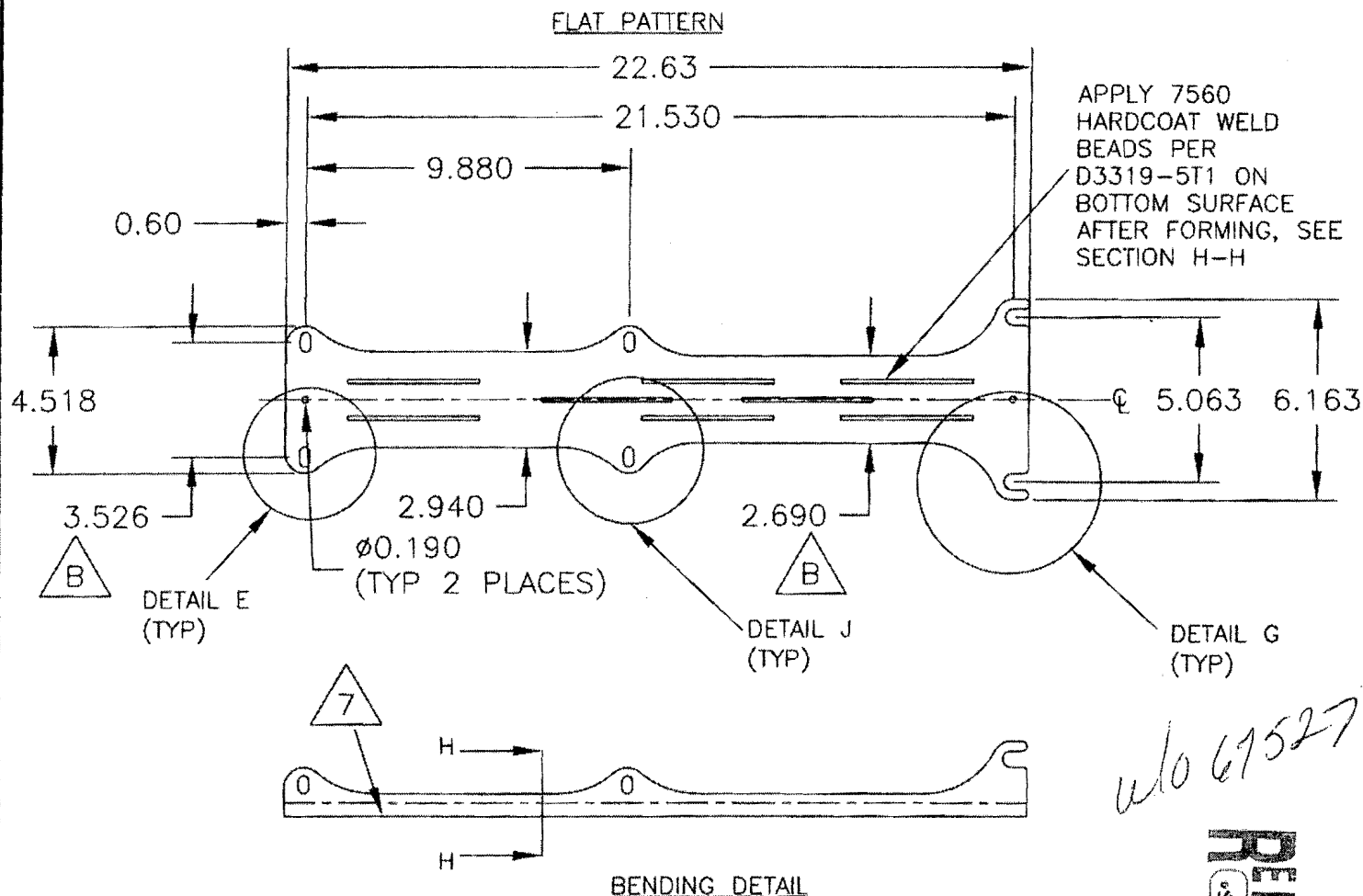
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DRAWN BY	HAWKESBURY, ONTARIO, CANADA
CHECKED	D3319
APPROVED	SHEET 2 OF 5
DATE	05.06.06
TITLE	WEARPLATE
SCALE	1:15

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W0667527

DART



D3319-5 WEARPLATE

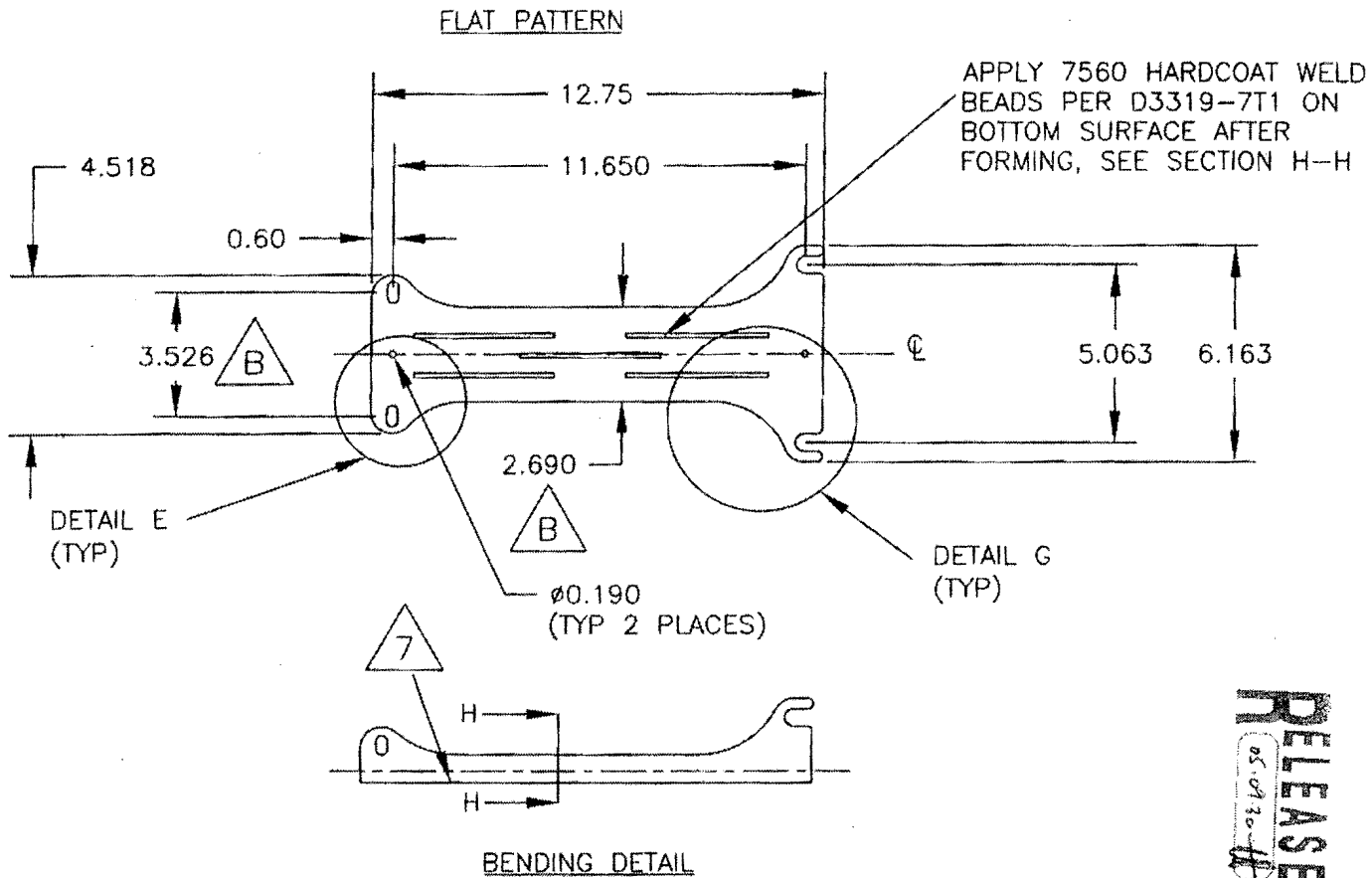
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	D41	DRAWN BY	D41	DART AEROSPACE LTD
CHECKED	#	APPROVED	#	HAMKESBURT, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 5
		SCALE	1:5	

RELEASED
05.09.30

DART

DESIGN	PH	DRAWN BY	GH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	GH	DRAWING NO.	REV. B
				D3319	SHEET 4 OF 5
DATE				TITLE	SCALE
05.06.06				WEARPLATE	1:5



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

w/o 47527

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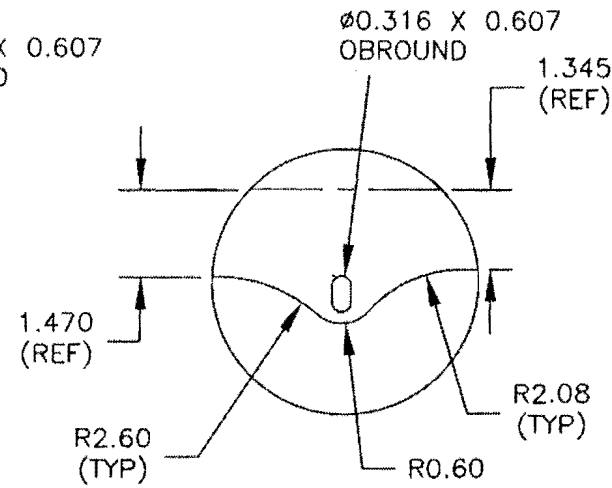
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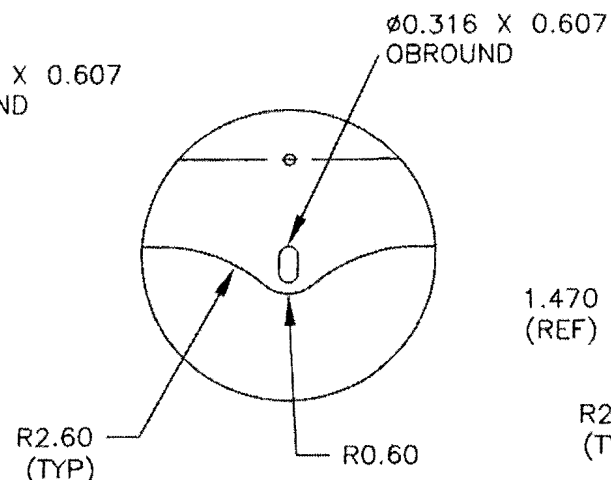
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CHECKED	APPROVED	DRAWING NO.	REV. B
PH	PH	D3319	SHEET 5 OF 5
DATE	TITLE	WEARPLATE	SCALE
05.06.06			1:3

RELEASED
05 09 2011

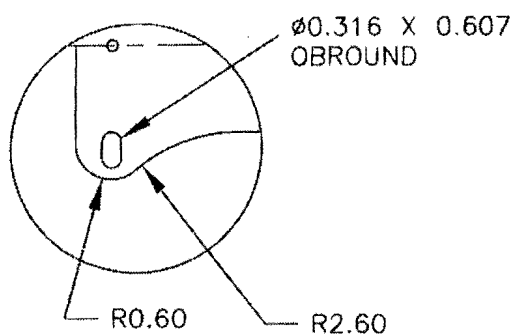
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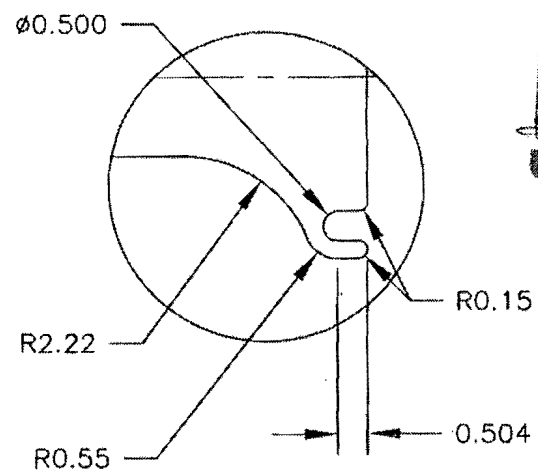
DETAIL J



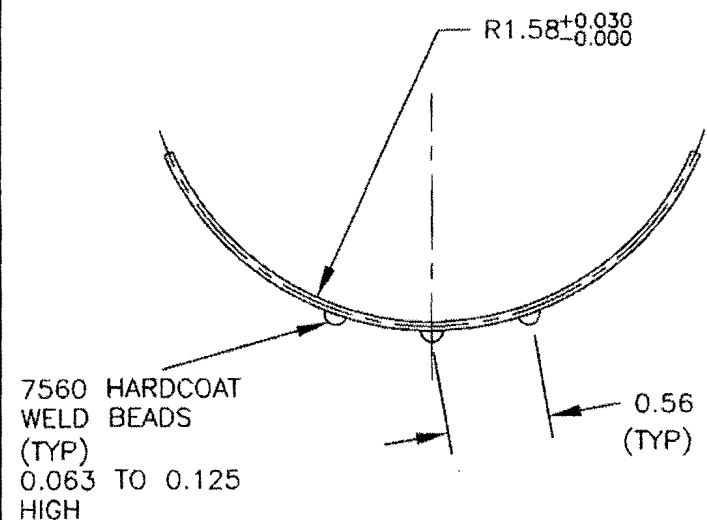
DETAIL F



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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